

Claims

1. A piston-type accumulator having an accumulator housing in the form of a cylindrical tube (1) in which a separating piston (15) which separates two working chambers (5 and 6) from each other may be moved in the axial direction within a piston stroke area (19) of the cylindrical tube (1), which is closed off at both axial ends by a closing component (7), at least one of which closing components is configured by shaping of a reshaping area (9) of the wall of the cylindrical tube (1) adjoining the piston stroke area (19) as an integral component of such wall, characterized in that there is provided in the interior of the cylindrical tube (1), at the point of transition from the piston stroke area (19) to the reshaping area (9), a stop element (25) restricting the movement of the separating piston (15) before the reshaping area (9) is reached.
2. The piston-type accumulator as claimed in claim 1, wherein the stop element (25) is locked positively against axial movement by retaining surfaces present on the inside of the wall of the cylindrical tube (1).
3. The piston-type accumulator as claimed in claim 2, wherein a first retaining surface positioned at the end of the piston stroke area (19) is formed by a shoulder (23) forming a recess in the inner wall of the cylindrical tube (1).
4. The piston-type accumulator as claimed in claim 3, wherein a second retaining surface positioned inside the reshaping area (9) is formed by the shaping of the wall of the cylindrical tube (1) configuring the closing component (7).

5. The piston-type accumulator as claimed in claim 3 or 4, wherein there is provided as stop element a support element in the form of a level plate (25) having at least one opening (29) as discharge opening for the operating medium present in the respective working chamber (5) and wherein the shoulder (23) forming the first retaining surface on the inner wall of the cylindrical tube (1) is a level step surface for installation on the opposite level circumferential edge of the plate (25).
6. The piston-type accumulator as claimed in claim 5, wherein the plate (25) has on the circumferential surface (29) a crowned, convex camber around which the wall of the cylindrical tube (1) is shaped during formation of the closing component (7), in order to configure the second retaining surface positioned in the reshaping area (9).
7. The piston-type accumulator as claimed in claim 1 or 2, wherein an annular element (31) round in cross-section is provided as stop element and wherein the shoulder (23) made in the inner wall of the cylindrical tube (1) and forming the first retaining surface forms a cambered partial surface of a seat (33) for the annular element (31).